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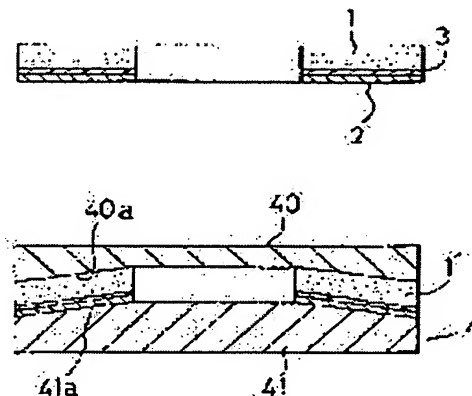
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(54) ANNULAR FRICTION MATERIAL

(57)Abstract:

PURPOSE: To improve adhesive strength even when materials are heat-bonded under a condition where they are forcibly warped in the direction reverse to the direction of warpage after heat-bonding by adhering and fixing integrally an annular plate friction base material and an annular thin-plate metallic reinforcing plate with a rubber-modified phenolic adhesive.

CONSTITUTION: An annular friction material composed of an annular plate friction base material 1 wherein a fibrous component and a binder component are main components and an annular thin-plate metallic reinforcing plate 2 which is adhered and fixed integrally on the surface of the base material 1, wherein the base material 1 and the reinforcing plate 2 are integrally adhered and fixed with a rubber-modified phenolic adhesive 3 and the frictional face is substantially on the same plain. Both members 1 and 2 are heat-bonded under a condition where a laminated body 1 is warped upward by using a jig 4 constituted of a top force 40 and a bottom force 41.



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